

Work Order ID 65558

January 19, 2011 1:44:31 PM



Page 1

Item ID: D3651-7

Accept



Setup Start



Revision ID:

Item Name: Bottom Flange

Stop



Start Date: 1/20/11 Start Qty: 5.00



Cust Item ID:

Required Date: 1/28/11 Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan:

MUF

Date:

11-01-19

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3651

Rev B

100

0.00



FLOW WATERJET

Waterjet

Memo

0.00

FLOW CNC Waterjet

304.018

1-Cut as per Dwg D3651

Dwg Rev: *B*

Prog Rev: *B*

2-Deburr if necessary

SP 11/01/27

B11-1-26

(6)

(6)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-1-26

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Sulok7

(x6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3651-7

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Setup Start



Revision ID:

Stop



Item Name: Bottom Flange

Start Date: 1/20/11 Start Qty: 5.00



Cust Item ID:

Required Date: 1/28/11 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 Brake NC Brake NC	Form as per dwg NC BRAKE Memo	0.00 0.00		SB 11/02/02		(6)			
170 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		Sul02/02		(x6)			
180 Packaging Packaging	Identify as per dwg & Stock Location: <u>GA</u> Memo B 655-73	0.00 0.00		SB 11/02/03		(6)			

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NOTE: Date & initial all entries

Work Order ID 65558

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Item ID: D3651-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Bottom Flange

Start Date: 1/20/11 Start Qty: 5.00



Cust Item ID:

Required Date: 1/28/11 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/02/04 *[Signature]**MF*

11-02-03

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 65558



Parent Item: D3651-7



Parent Item Name: Bottom Flange

Start Date: 1/20/11

Required Date: 1/28/11

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP RevA 10.11.04 as per revB DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S26GA		Purchased	No			100	sf	109.6600	0.3	1.578947			



304/316 0.018 SHEET



HB11-1-04

Location

Loc Qty

Loc Code

MAT20

109.66

109398

20.06

112885

89.6

112885

(6)

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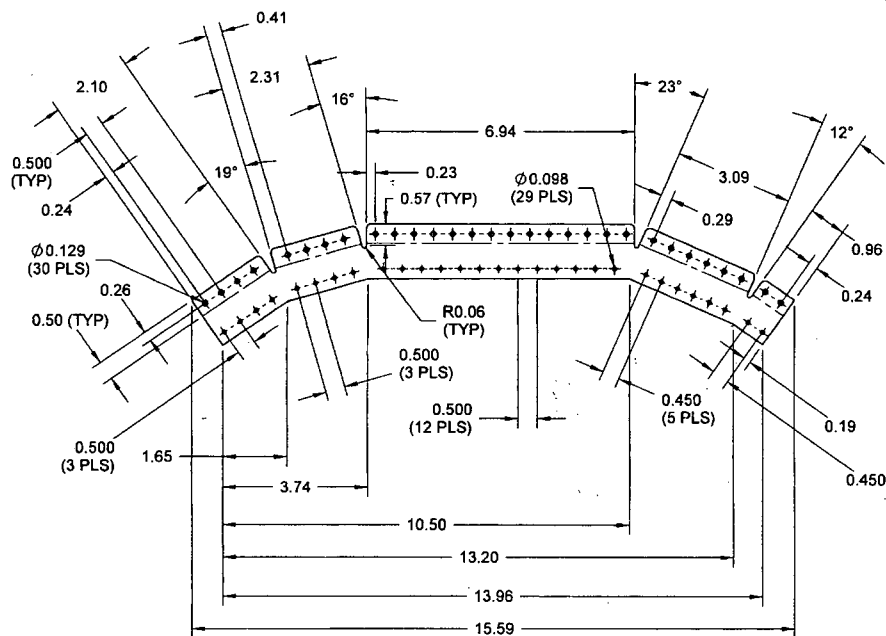
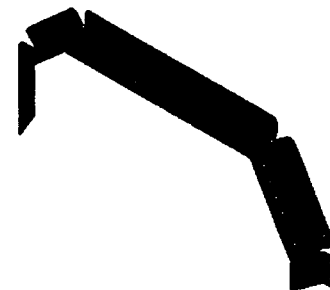
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

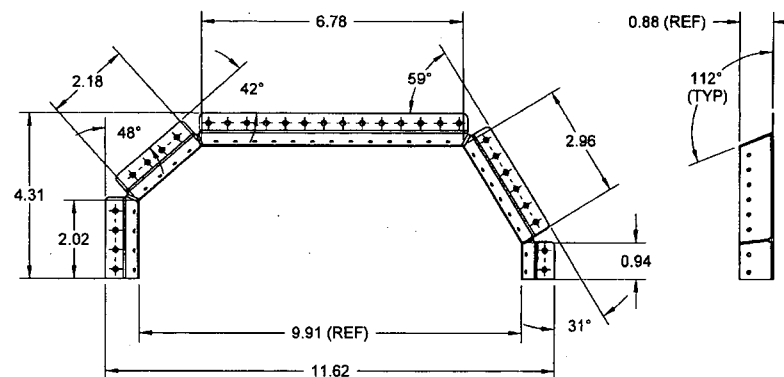
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65558



D3651-7F FLAT PATTERN



D3651-7 BOTTOM FLANGE BEND DETAIL
(MAKE FROM D3651-7F FLAT PATTERN)

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO. D3651	REV. B SHEET 8 OF 9
MFG. APPR.		TITLE AFT BASE ASSEMBLY	SCALE 1:3
DE APPR.		COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.01.07		

W/O:		WORK ORDER CHANGES					
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